

Work Order ID 93264

\*93264\*

Page 1

November-15-12 10:41:52 AM

**Item ID:** D350-567-141

Accepted

\*N900040100\*

## Setup Start

\*NS1\*

**Revision ID:**

**Item Name:** Floor Window Closeout Installation

**Start Date:** 11/15/12      **Start Qty:** 6.00

\*6\*

**Cust Item ID:**

**Required Date:** 12/07/12      **Req'd Qty:** 6.00

\*6\*

**Customer:**

### **Reference:**

Approvals:      Process Plan:      MLJ

Date: 12-11-15

## Tooling

Date:

### Run Start

\*NR1\*

OC

Date:

**SPC (Y/N):**

Date:

Stop

\*NR2\*

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Use-as-is <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>					
	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>						
	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>							
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										
FAULT CATEGORY										
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions						
				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other						

Work Order ID 93264

\*93264\*

Page 2

November-15-12 10:41:52 AM

Item ID: D350-567-141

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Floor Window Closeout Installation

Start Date: 11/15/12 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 12/07/12 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

\*130\*

Packaging

Packaging

0.00

0.00

SK 12/12/21

Packaging

Memo  
Identify and pack for shipping as per PPP D350-567-141  
Location: FC 059A

140

QC21- Final Inspection - Work Order Release

0.00

\*140\*

QC

Quality Control

Memo

0.00

CK 12/12/21

MF

12-12-21

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

# **WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

# Picklist Print

November-15-12 10:41:50 AM

Page 1

Work Order ID: 93264

Parent Item: D350-567-141

Start Date: 11/15/12

Required Date: 12/07/12

Parent Item Name: Floor Window Closeout Installation

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 11.11.09 new issue DD verf:JLM  
ECN12-511 DD VERF:EC

IPP REV:B 12.01.23 AS PER  
IPP REV:C 12.03.05 AS PER ECN12-537 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3802-1 Window Seal		Manufactured	No			110	f	407.1400	2	12	1		

24" 024

6x24" Sm 6X

Location	Loc Qty	Loc Code
ST408	407.14	
56881	0.75	
81021	2	
81868	404.39	

81868

D4434-041  
Fwd Bracket Assembly

Sm 6X

Location	Loc Qty	Loc Code
ST272	4	
85859	4	
ST274	1	
83538	1	

6 93376

D4434-047  
Cover Assembly

Sm 6X

Location	Loc Qty	Loc Code
ST273	2	
85839	2	

936318

D4435-045  
T/R Bellcrank Cover Assembly

Sm 6X

Location	Loc Qty	Loc Code
ST273	1	
83535	1	

6 93214

D4435-91  
Bracket

Sm 6X

Location	Loc Qty	Loc Code
ST273	1	
83535	1	

12- B93342

D4436-041  
Aft Bracket Assembly

Sm 6X

Location	Loc Qty	Loc Code
ST273	1	
83535	1	

6

93215

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
		Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
		Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
		Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
		Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									
FAULT CATEGORY									
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions					
				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other					

# Picklist Print

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Work Order ID: 93264

Parent Item: D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 11/15/12

Required Date: 12/07/12

Start Qty: 6.00

Required Qty: 6.00

D4441-1

Rubber Seal

24

1-270

Smf

(X)

Manufactured

No

110

f

651.1146

12

## Location

## Loc Qty

## Loc Code

ST412

651.1146

74760

6.119

79385

0.0476

80763

159.54

86185

485.408

80763

AN3-3A

Bolt

Smf (X)

Purchased

No

110

Each

286.0000

42

## Location

## Loc Qty

## Loc Code

ST350

286

122800

186

123352

100

123352

AN525-832R7

Screw

Smf (X)

Purchased

No

110

Each

434.0000

12

MS21042L06

Nut

Smf (X)

Purchased

No

110

Each

331.0000

42

120560

## Location

## Loc Qty

## Loc Code

315

258

122441

258

ST317

73

122151

73

122441

NCR: Yes / No

# **WORK ORDER NON-COMPLIANCE / UPDATE**

DQA: Date: 1

QA Closed: Date:

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending				Bend				Grain			
Centre Not Concentric to O/S				BOM/Route				Hardware			
Cracks				Broken/Damaged				Inspection Incomplete			
Crushed/Crimped.				Burrs				Instructions Incomplete/Unclear			
Cuffs				Contamination				Maintenance			
Heat Treat				Countersink				Mislabeled			
Inspection Strip in Tube				Cut Too Short				Misread			
Ripples in Bend				Drill Holes				Offset			
Torque Waves in Extrusion				Drawing				Out of Calibration			
Turning Sequence				Finish				Out of Sequence			
Wave/Twist in Tube				Folio				Outside Dimensions			
<input type="checkbox"/> Ovalized <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Weld <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other											

# Picklist Print

November-15-12 10:41:51 AM

Page 3

Work Order ID: 93264

Parent Item: D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 11/15/12

Required Date: 12/07/12

Start Qty: 6.00

Required Qty: 6.00

MS21042L08

Nut

Purchased

No

110

Each

860.0000



12

Smp 6X

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
315	9	
122452	9	
ST315	500	
122814	500	
ST317	351	
122141	351	

MS21042L3

Nut

Purchased

No

110

Each

2,276.0000



30

3m 6X

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
316	541	
122452	541	
ST300	225	
117885	32	
119017	55	
119075	138	
ST314	1189	
123265	1189	
ST317	321	
122141	321	

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Machining <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
NCR No. _____	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
	Work Order Update <input type="checkbox"/>			Composite <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Supplier <input type="checkbox"/>	Other <input type="checkbox"/>			
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										
FAULT CATEGORY										
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions						
				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other						

# Picklist Print

November-15-12 10:41:51 AM

Page 4

Work Order ID: 93264

Parent Item: D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 11/15/12

Required Date: 12/07/12

Start Qty: 6.00

Required Qty: 6.00

MS21059L3

Purchased

No

110

Each

217.0000

6X

12

Nut Plate

6X

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
302	10	
121185	10	
ST301	28	
118614	8	
119546	20	
ST302	120	
120308	13	
120833	1	
121444	100	121444
121524	6	
ST316	59	
122814	59	

MS35206-229

Purchased

No

110

Each

65.0000

6X

42

Screw

5m 6X

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST293	65	
121039	65	

NAS1149F0332P

Purchased

No

110

Each

1,138.0000

12X

72

WASHER

5m 6X

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
275	162	
122441	162	
ST275	776	
117735	13	
119225	8	
121259	138	
121825	14	
122063	600	
17317	3	
ST295	200	
123352	200	

121039

72

11/11/12

6X

121259 20P

123352 52P

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## **WORK ORDER NON-COMPLIANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending	General			Grain	General			Ovalized	Pressure/Forced		
Centre Not Concentric to O/S	Bend	General			Hardware	General			Over/Under tolerance	Temperature/Cure	
Cracks	BOM/Route	General			Inspection Incomplete	General			Part Incorrect	Weld	
Crushed/Crimped.	Broken/Damaged	General			Instructions Incomplete/Unclear	General			Part Lost/Missing	Wrong Stock Pulled	
Cuffs	Burrs	General			Maintenance	General			Part Moved		
Heat Treat	Contamination	General			Mislabeled	General			Positioned Wrong		
Inspection Strip in Tube	Countersink	General			Misread	General			Power Loss/Surge		
Ripples in Bend	Cut Too Short	General			Offset	General					
Torque Waves in Extrusion	Drill Holes	General			Out of Calibration	General					
Turning Sequence	Drawing	General			Out of Sequence	General					
Wave/Twist in Tube	Finish	General			Outside Dimensions	General					
	Folio	General				General					

# Picklist Print

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Work Order ID: 93264

Parent Item: D350-567-141

Parent Item Name: Floor Window Closeout Installation

Start Date: 11/15/12

Required Date: 12/07/12

Start Qty: 6.00

Required Qty: 6.00

NAS1149EN616P

WASHER

Purchased No

110 Each 641.0000

141

84

Smt 6Y

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST275	641	
117317	15	
120560	626	

NAS1149EN816P

WASHER

Purchased No

Each 725.0000

141

12

Smt 6Y

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST275	725	
117316	215	
121039	510	

121439

NCR: Yes / No

# **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

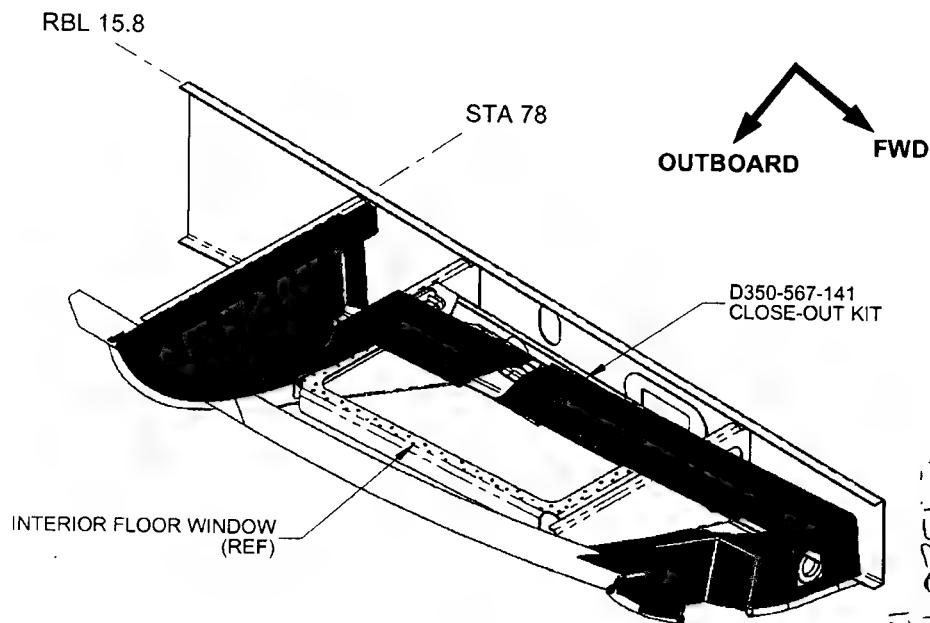
Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear	General										
	Bending <input type="checkbox"/>	Grain <input type="checkbox"/>	Ovalized <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>							
	Centre Not Concentric to O/S <input type="checkbox"/>	Hardware <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>							
	Cracks <input type="checkbox"/>	Inspection Incomplete <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Weld <input type="checkbox"/>							
	Crushed/Crimped. <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>							
	Cuffs <input type="checkbox"/>	Maintenance <input type="checkbox"/>	Part Moved <input type="checkbox"/>								
	Heat Treat <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>								
	Inspection Strip in Tube <input type="checkbox"/>	Misread <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>								
	Ripples in Bend <input type="checkbox"/>	Offset <input type="checkbox"/>									
	Torque Waves in Extrusion <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>									
	Turning Sequence <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>									
	Wave/Twist in Tube <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>									

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-567 REV. D OR EARLIER  
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-567 REV. 1 OR EARLIER  
REF CANADIAN STC: SH92-18  
FAA STC: SH989NE  
FAA STC: SH990NE

## 1.0 Purpose

The purpose of this service instruction is to add the D350-567-141 Close-out Kit, which is intended for customers wishing to operate their aircraft with the interior floor window removed. The D350-567-141 Floor Window Close-out Kit provides a barrier around the interior and exterior vertical reference floor window to prevent objects from falling into the aircraft controls when the interior floor window is removed as shown in Figure 1.



**Figure 1. Floor Window Close-out Kit Installation**

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED <i>[Signature]</i>	
BY:	D. SHEPHERD (DE # 02)
DATE:	12.03.13
CERT. NO.:	SH92-18
ISSUE NO.:	6

REV.	DESCRIPTION		BY	DATE
C	CORRECT TYPO NAS1149FN816P WAS NAS1149FN882P		RF	12.03.13
B	MS35206-229 WAS AN525-632R6; NAS1149FN616P (Qty 14) WAS (Qty 9); MS21042L06 (Qty 7) WAS (Qty 9); ADD AN525- 832R7, NAS1149FN882P & MS21042L08		RF	12.02.22
A	NEW ISSUE		RF	12.01.09
DESIGN	RF	DART AEROSPACE LTD		
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C	
MFG. APPR.	N/A	DSI 9590	SHEET 1 OF 12	
APPROVED	<i>[Signature]</i>	TITLE	SCALE	
DE APPR.	<i>[Signature]</i>	FLOOR WINDOW CLOSE-OUT KIT NTS		
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## 2.0 Part List

Qty -141	Part Number	Description
X	D350-567-141	FLOOR WINDOW CLOSE-OUT KIT
1	D3802-1-024	SEAL (24")
1	D4434-041	FWD BRACKET ASSEMBLY
1	D4434-047	COVER ASSEMBLY
1	D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	D4435-9	BRACKET
1	D4436-041	AFT BRACKET ASSEMBLY
1	D4441-1-240	RUBBER SEAL (24")
7	AN3-3A	BOLT
2	AN525-832R7	SCREW
7	MS21042L06	NUT (OR MS21042-06)
2	MS21042L08	NUT (OR MS21042-08)
5	MS21042L3	NUT (OR MS21042-3)
2	MS21059L3	NUTPLATE
7	MS35206-229	SCREW
12	NAS1149F0332P	WASHER (AN960-10L)
14	NAS1149FN616P	WASHER (OR AN960-6L)
2	NAS1149FN816P	WASHER (OR AN960-8L)

## 3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141 Kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141 Floor Window Close-out Kit	3.9 lb 1.77 kg	17.9 in 0.45 m	69.8 in-lb 0.80 m-kg	65.5 in 1.66 m	255.5 in-lb 2.94 m-kg

## 4.0 Installation Procedure

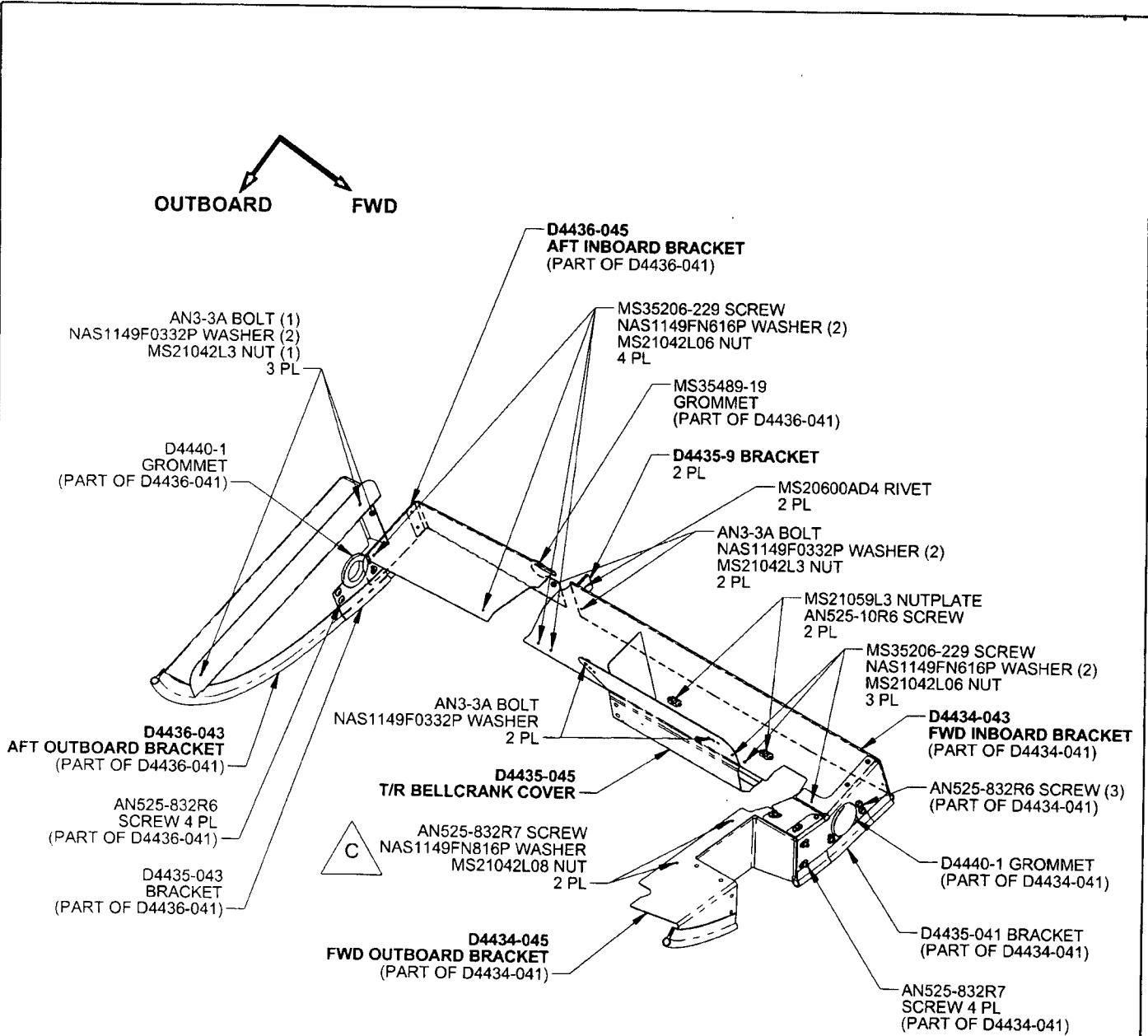
Notes:

- 1) Figure 2 shows the general arrangement and installation of the D350-567-141 Close-out Kit. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- 2) In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
  - D350-567-115 — OK to remove D3295-041
  - D350-567-031 — OK to remove D3212-1
  - D350-567-011 — OK to remove D2214
  - D350-567-021 — OK to remove D2951
- 3) It is acceptable to drill/trim the D350-567-141 Close-out Kit as required to improve fit.

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BY:	D. SHEPHERD (DE # 02)
DATE:	12.03.13
CERT. NO.:	SH92-18
ISSUE NO.:	6

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>DSI 9590</b> REV. C SHEET 2 OF 12 TITLE <b>FLOOR WINDOW CLOSE-OUT KIT</b> NTS
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CHECKED	<i>[Signature]</i>	
MFG. APPR.	N/A	
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**Figure 2. Floor Window Close-out Kit Installation**

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CHECKED	<i>[Signature]</i>	DRAWING NO. DSI 9590
MFG. APPR.	N/A	REV. C
APPROVED	<i>[Signature]</i>	SHEET 3 OF 12
DE APPR.	<i>[Signature]</i>	TITLE SCALE
DATE	12.03.13	FLOOR WINDOW CLOSE-OUT KIT NTS
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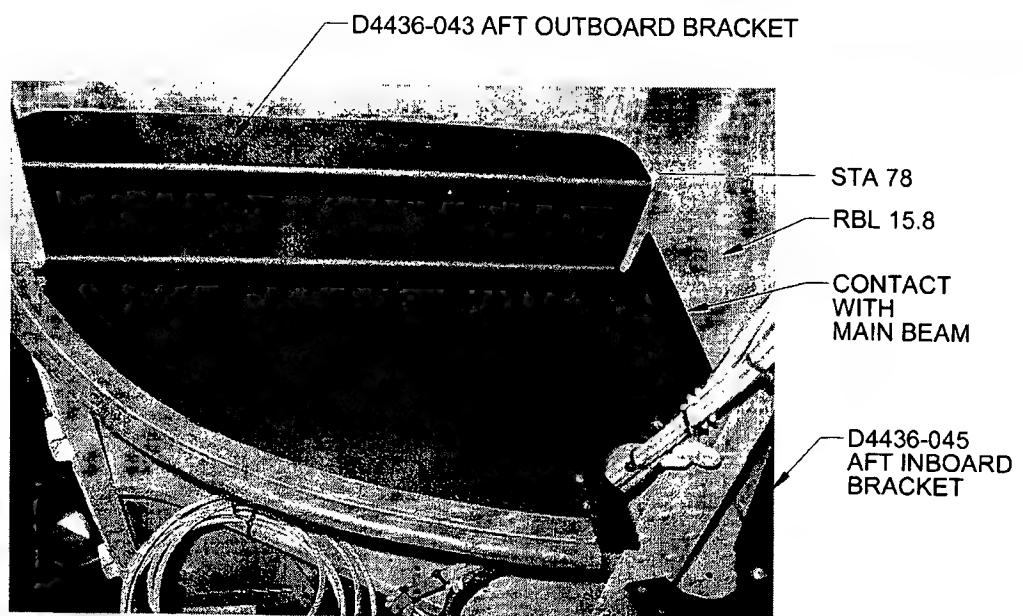
- 4.1 Temporarily install D4436-043 Aft Outboard Bracket and D4436-045 Aft Inboard Bracket using clecos and/or clecos clamps. Before drilling holes:
- Position the D4436-043 Aft Outboard Bracket so the flange contacts the main beam as shown in Figure 3.
  - Confirm that the D4436-043 Aft Outboard Bracket and beam angle are parallel as shown in Figure 4.
- 4.2 Temporarily install D4434-043 Fwd Inboard Bracket and D4434-045 Fwd Outboard Bracket using clecos and cleco clamps. Confirm there is no contact between D4436-045 Aft Inboard Bracket and D4434-043 Fwd Inboard Bracket and main beam gusset as shown in Figure 5.
- 4.3 If aircraft is equipped with Collective Circuit Breaker Board box trim D4434-043 Fwd Inboard Bracket as shown in Figure 14. Install D4434-047 Cover as shown in Figure 13. Note: Confirm the D4434-047 Cover fits over the Collective Circuit Breaker Board box. Adjust opening as required.
- 4.4 Drill off rivets holding plastic wire bundle stand offs. Transfer drill  $\varnothing$ 0.144 holes to D4436-045 Aft Inboard Bracket per Figure 6. Transfer drill 2 x  $\varnothing$ 0.144 holes to D4434-043 Fwd Inboard Bracket per Figure 7. Transfer drill 2 x  $\varnothing$ 0.144 holes for D4434-043 Fwd Inboard Bracket per Figure 8. Before drilling confirm the D4434-043 and D4436-045 brackets are flush with outboard edge of main beam flange. Assemble D4436-045 Aft Inboard Bracket and D4434-043 Fwd Inboard Bracket and wire bundle stand offs to main beam flange using MS35206-229 screw, NAS1149FN616P washer and MS21042L06 nut.
- 4.5 Install D4436-043 Aft Outboard Bracket using AN3-3A bolt and NAS1149F0332P washer and MS21042L3 nut per Figure 9.
- 4.6 Remove 2 rivets holding RH heating plastic stand off as shown in Figure 10. Position the D4435-9 Brackets on the in/outboard sides of the cross beam and transfer drill 2 x  $\varnothing$ 0.129 holes from crossbeam to both D4435-9 Brackets. Install D4435-9 Brackets and RH heating plastic stand off using MS20600AD4 rivets or equivalent.
- 4.7 Drill a pilot hole from D4435-9 Bracket to the D4434-045 Fwd Inboard Bracket and D4436-045 Aft Inboard Bracket and open to  $\varnothing$ 0.191. Install AN3-3A bolt, NAS1149F0332P washer and MS21042L3 nut as shown in Figure 10. Be sure to maintain edge distance.
- 4.8 Transfer drill 2 x  $\varnothing$ 0.144 holes from crossbeam to D4434-045 Fwd Outboard Bracket if holes exist in crossbeam. If holes do not exist, drill 2 x  $\varnothing$ 0.144 holes at either end of D4434-045 bracket as shown in Figure 11. Install AN525-832R7 Screws, NAS1149FN816P washer and MS21042L08 nuts.
- 4.9 Align D4435-045 T/R Bellcrank Cover with existing holes in RH seat track lower frame and temporarily install using clecos and/or cleco clamps as shown in Figure 12.
- 4.10 Transfer drill 2 x  $\varnothing$ 0.098 holes from D4435-045 T/R Bellcrank Cover to D4434-043 Fwd Inboard Bracket. Open holes to  $\varnothing$ 0.191 and install MS21059L3 nut plate into D4434-043 Fwd Inboard Bracket as shown in Figure 12 and Figure 13. Install D4435-045 T/R Bellcrank Cover using AN525-10R6 screw, AN3-3A bolt and NAS1149F0332P washer per Figure 12 and Figure 13.
- 4.11 The D4440-1 grommets are provided to facilitate the routing of wiring harness thru the close-out kit as required. The wiring harness should be secure to the aircraft structure per AC 43.13.13-1B or AS350 Chapter 20.02.01.
- 4.12 Use the D3802-1-024 Seal to fill gaps between the brackets and the cowlings that are larger than 0.25 inch.
- 4.13 Perform travel/interference check of the flight controls to ensure there is no interference and all controls still have full travel.
- 4.14 Ensure there is a gap between the components of the D350-567-141 Close-out Kit and the aircraft structure so that the Close-out Kit does not chafe, interfere, or cause damage to the surrounding aircraft structure. In areas where the D350-567-041 Close-out Kit may contact the aircraft structure, protect from abrasion using chafing tape or a layer Proseal 890 or MIL-S-8802 class B2 sealant or equivalent as required.



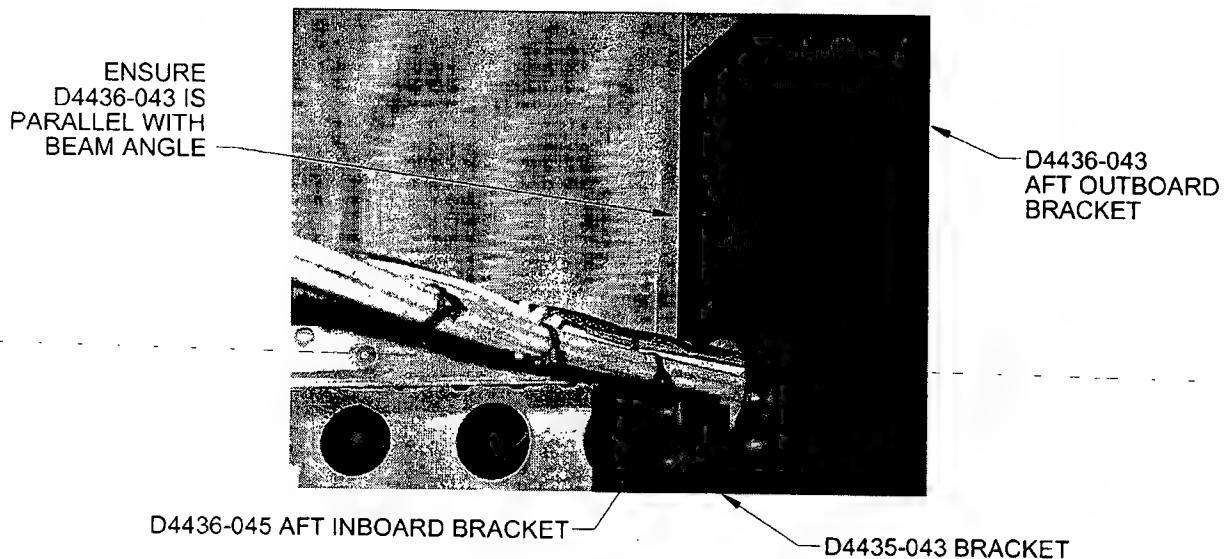
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MFG. APPR.	N/A	
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**Figure 3. D4436-043 Aft Outboard Bracket Installation**

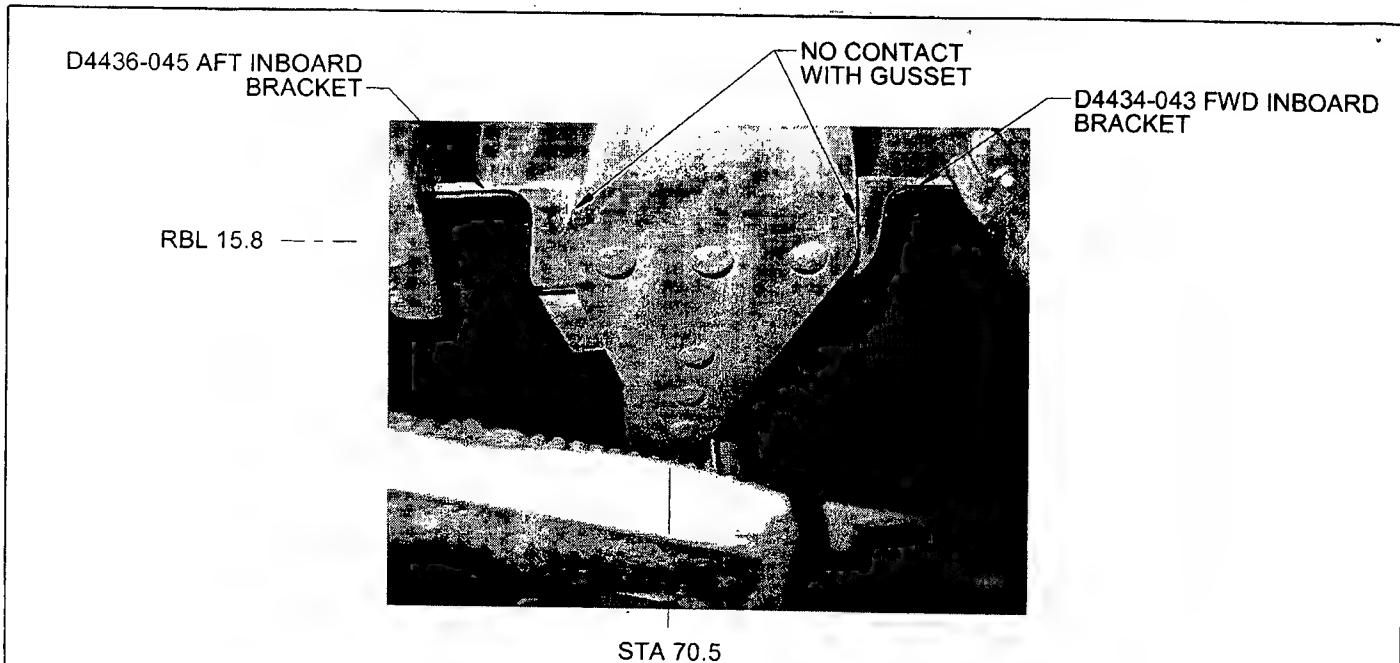


**Figure 4. D4436-043 & D4435-043 Brackets Installation**

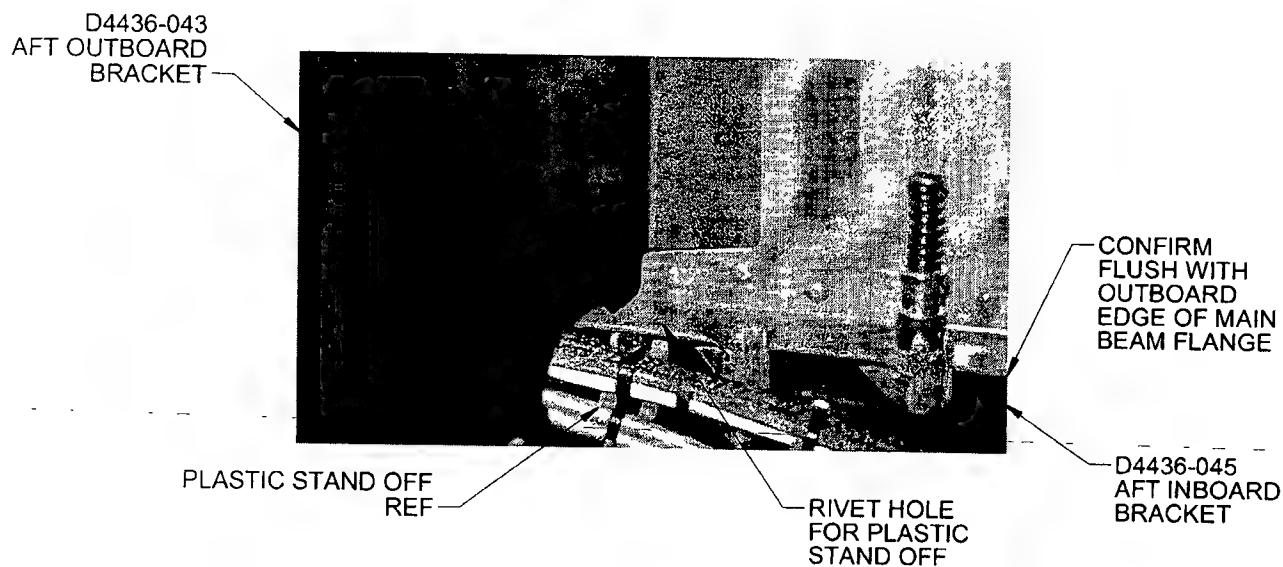
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**Figure 5. D4436-045 & D4434-043 Brackets Installation**

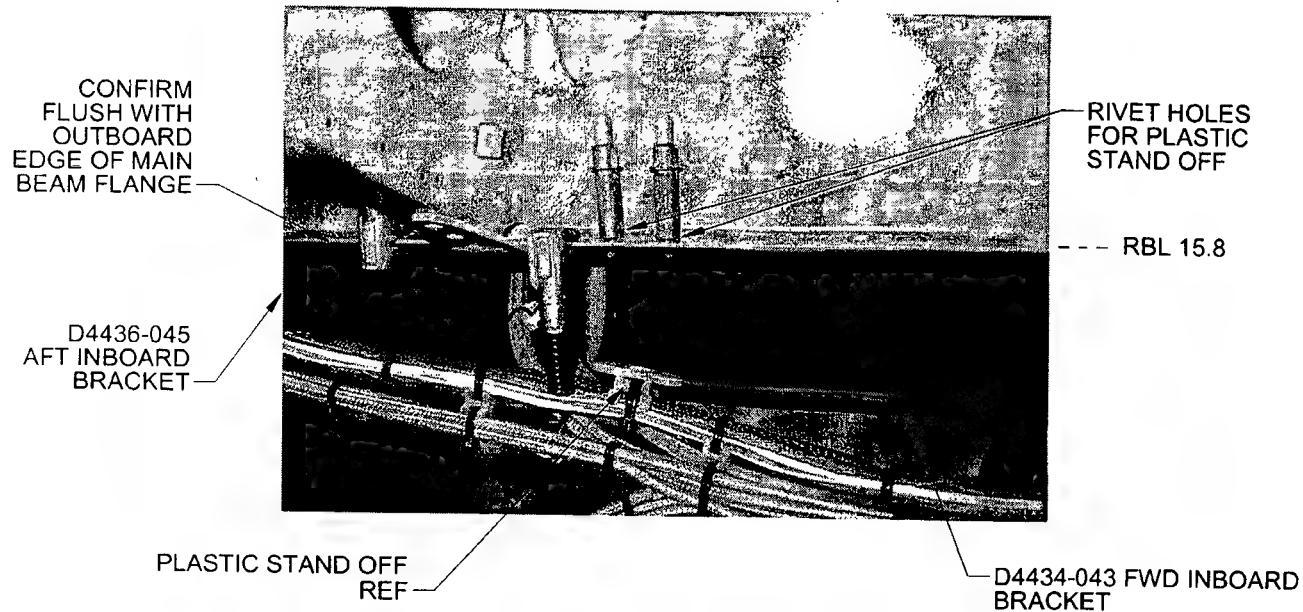


**Figure 6. D4436-043 & D4436-045 Brackets Installation**

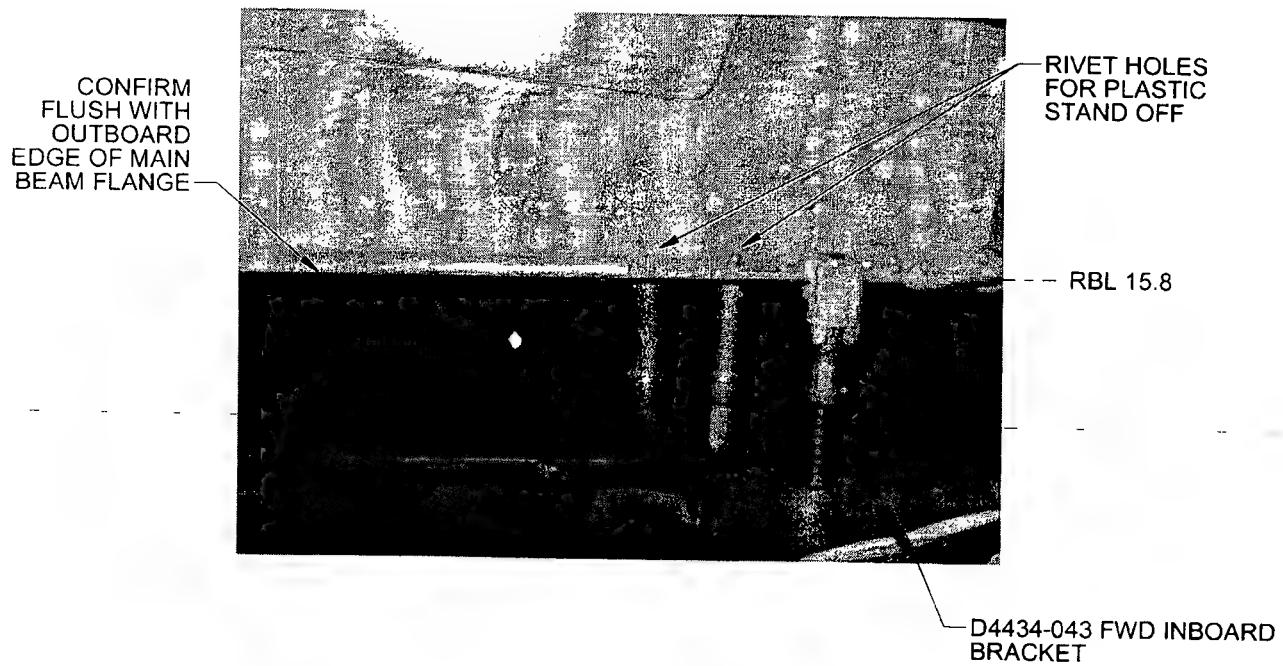
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**Figure 7. D4434-043 & D4436-045 Brackets Installation**



**Figure 8. D4434-043 Fwd Inboard Bracket Installation**

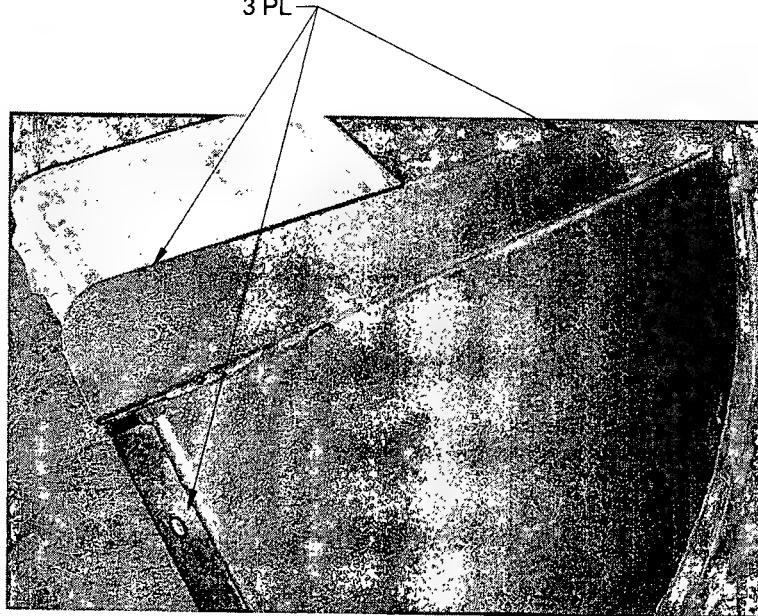
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INSTALL  
 D4436-043  
 AFT OUTBOARD BRACKET  
 USING  
 AN3-3A BOLT (1)  
 NAS1149F0332P WASHER (2)  
 MS21042L3 NUT (1)  
 3 PL



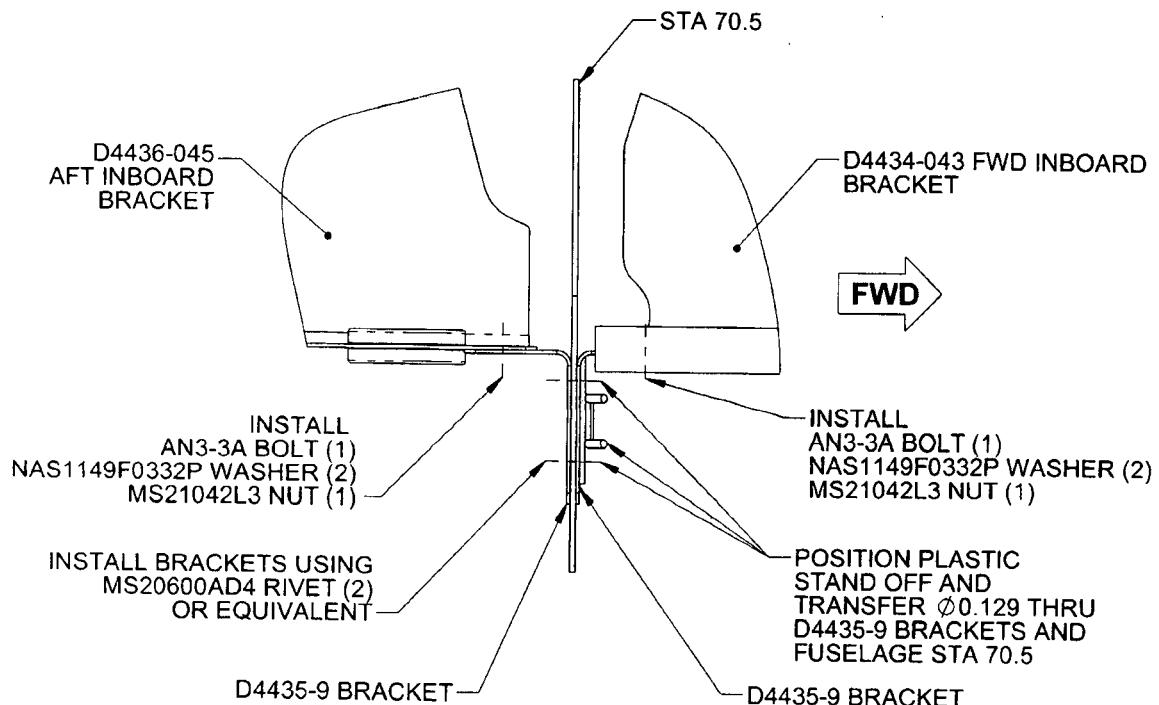
**Figure 9. D4436-043 Aft Outboard Bracket Installation**

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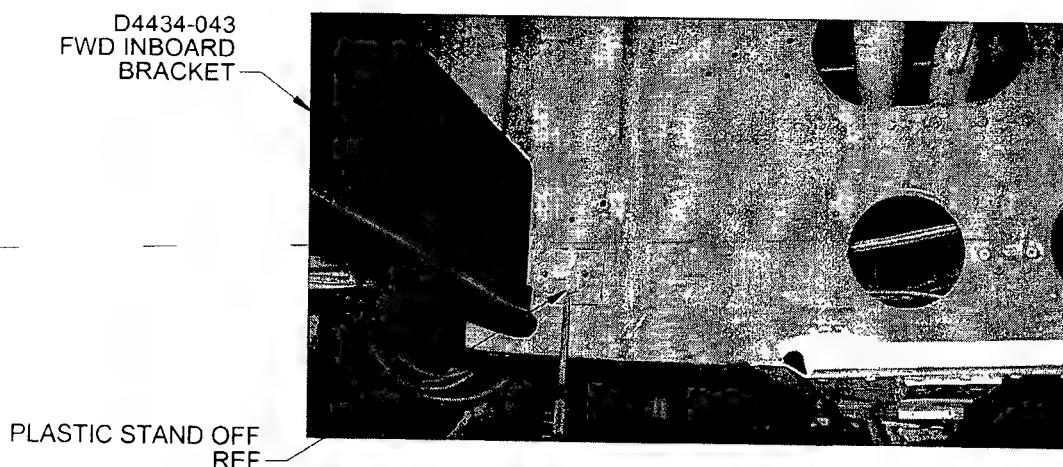


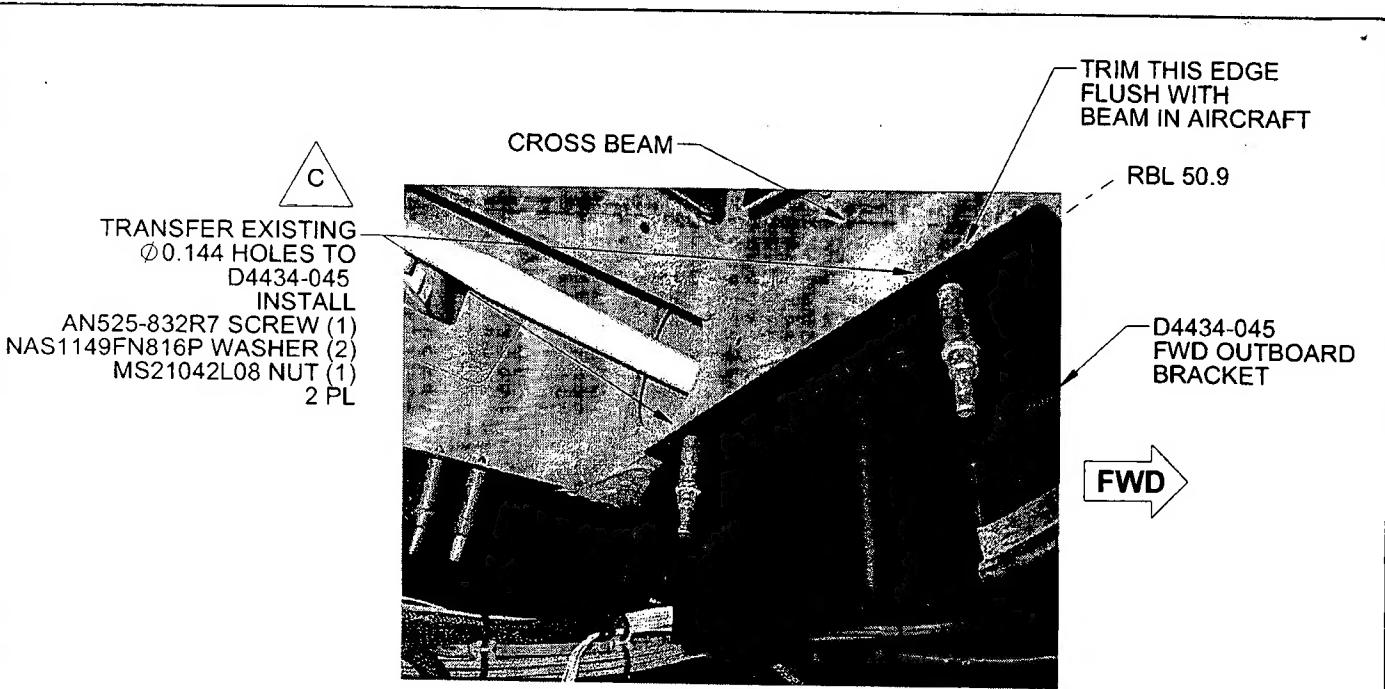
Figure 10. D4434-043 and D4435-9 Brackets Installation

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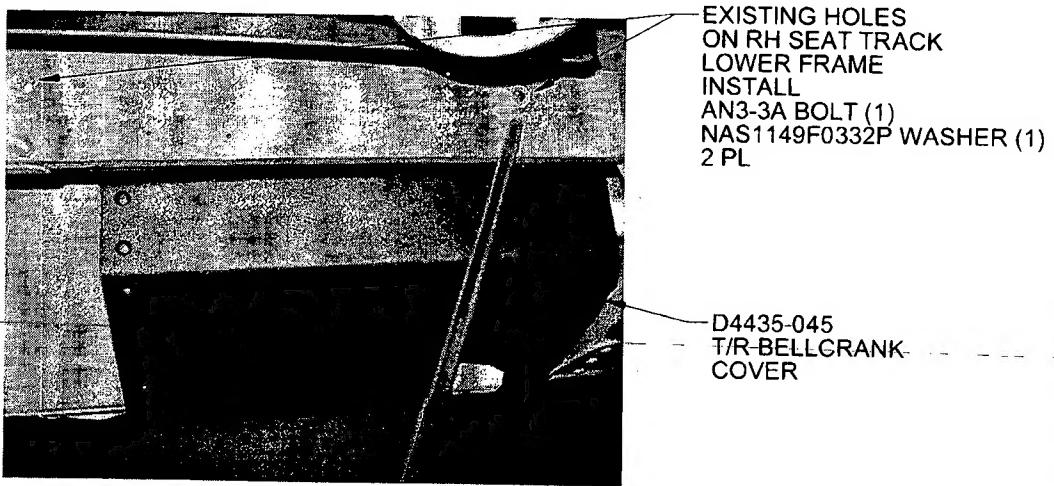
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**Figure 11. D4434-045 Bracket Installation**



**Figure 12. D4435-045 T/R Bellcrank Cover Installation**

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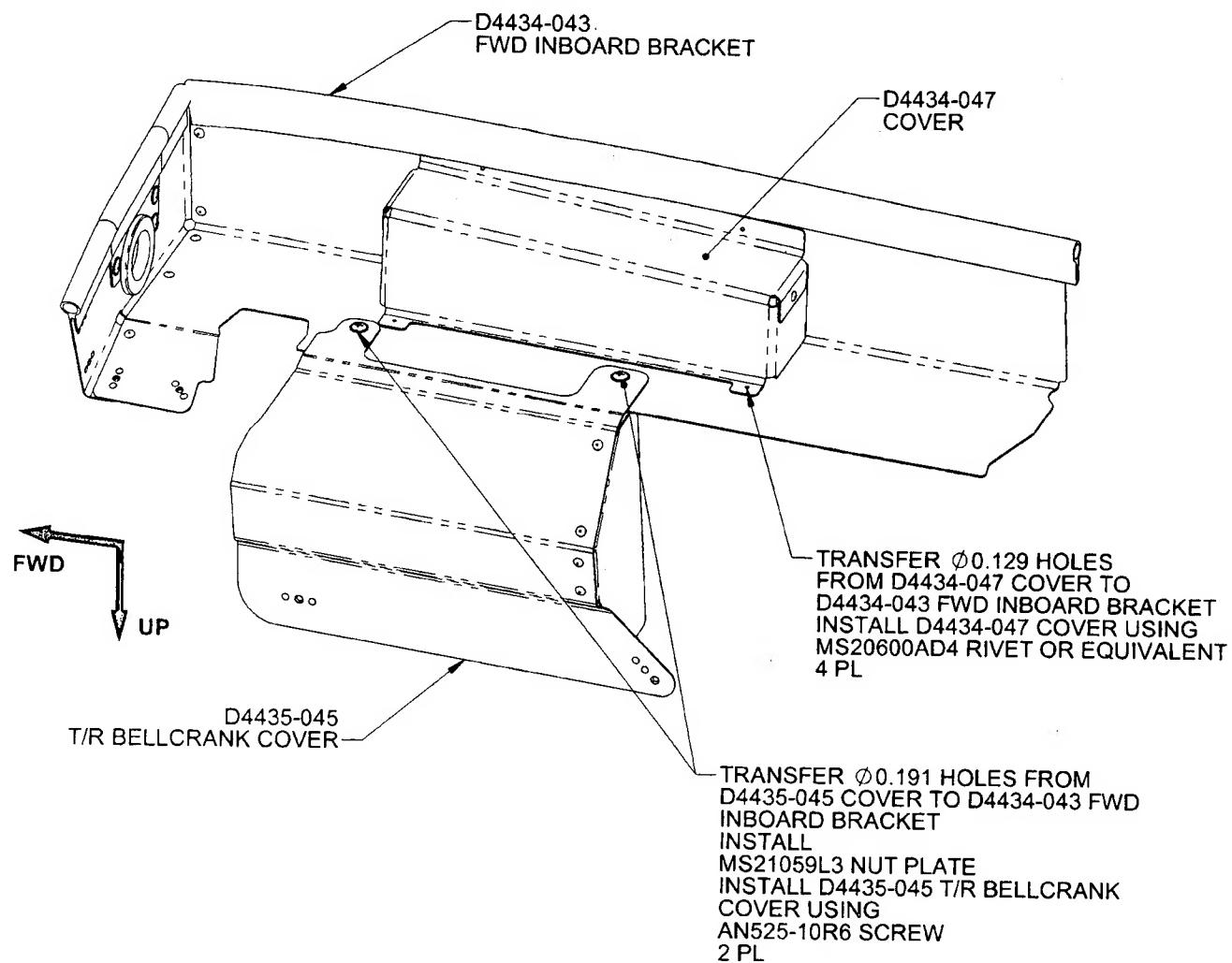


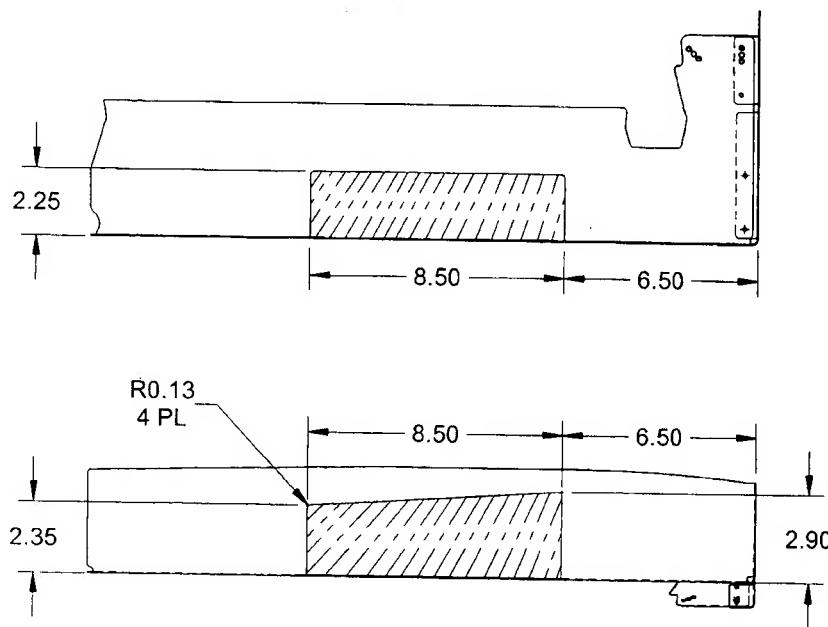
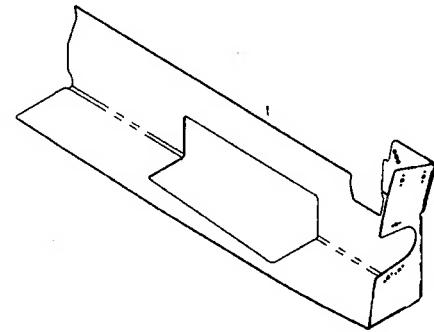
Figure 13. D4435-045 & D4434-047 Cover Installation

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**Figure 14. D4434-043 Fwd Inboard Bracket Cutout**

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SM3

## 2.0 Part List

Qty -141	Part Number	Description
X	D350-567-141	FLOOR WINDOW CLOSE-OUT KIT
1	D3802-1-024	SEAL (24")
1	D4434-041	FWD BRACKET ASSEMBLY
1	D4434-047	COVER ASSEMBLY
1	D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	D4435-9	BRACKET
1	D4436-041	AFT BRACKET ASSEMBLY
1	D4441-1-240	RUBBER SEAL (24")
7	AN3-3A	BOLT
2	AN525-832R7	SCREW
7	MS21042L06	NUT (OR MS21042-06)
2	MS21042L08	NUT (OR MS21042-08)
5	MS21042L3	NUT (OR MS21042-3)
2	MS21059L3	NUTPLATE
7	MS35206-229	SCREW
12	NAS1149F0332P	WASHER (AN960-10L)
14	NAS1149FN616P	WASHER (OR AN960-6L)
2	NAS1149FN816P	WASHER (OR AN960-8L)



## 3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141 Kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141 Floor Window Close-out Kit	3.9 lb 1.77 kg	17.9 in 0.45 m	69.8 in-lb 0.80 m-kg	65.5 in 1.66 m	255.5 in-lb 2.94 m-kg

## 4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141 Close-out Kit. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
  - D350-567-115 — OK to remove D3295-041
  - D350-567-031 — OK to remove D3212-1
  - D350-567-011 — OK to remove D2214
  - D350-567-021 — OK to remove D2951
- It is acceptable to drill/trim the D350-567-141 Close-out Kit as required to improve fit.

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